

DQA: _____ Date: _____



WORK ORDER NON-CONFORMANCE / UPDATE

QA Closed: _____ Date: _____

Work Order update only ☐

Work Order: _____ Part No. _____ NCR No. _____	DISPOSITION Rework ☐ Scrap ☐ Use-as-is ☐ Suspected Unapproved ☐	AGAINST DEPARTMENT/PROCESS Skid-tube ☐ Machining ☐ Thermoforming ☐ Large Fab ☐ Cross tube ☐ Small Fab ☐ Finishing ☐ Composite ☐ Water Jet ☐ Prod. Eng. Coord. ☐ Rec/Store/Packaging ☐ Supplier ☐ Engineering ☐ Quality ☐ Other ☐			
Date : _____	Step #: _____	QTY Effective : _____		MRB (QSI042) Approval	
Description Work Order Deviation		Disposition		Completed By	
				Lead hand / Supervisor Approval Verification	
				QC / QA Coordinator Approval	
Root Cause		FAULT CATEGORY			
Environment ☐ Design ☐ Doc/Data ☐ Equip/Tooling ☐ Handling/Pre ☐ Material ☐ Internal Transport ☐ Tribal Knowledge ☐ LOA ☐ Substation ☐ Past Expiry Date ☐ Misidentified ☐ No Re-verification ☐ Operator ☐ Offset/Setup ☐ Supplier ☐ Training ☐ Use for Testing ☐ Poor Information ☐ Rushing ☐ Product Improvement ☐ Process Improvement ☐ Manufacturing Process ☐ Past Due ☐	Pressure/Forced ☐ Bending ☐ Centre Not Concentric ☐ Cracks ☐ Crimp/Kink/Ripple/Wave ☐ Cuffs ☐ Crushing ☐ Heat Treat ☐ Wave/Twist in Tube ☐ Marks/Chatter ☐ Temperature/Cure ☐ Set-up ☐ BOM/Route ☐ Broken/Damage/Defect ☐ Inspection Incomplete/Unqualified ☐ Contamination ☐ Countersink ☐ Cut Too Short ☐ Instructions Incomplete/Unclear ☐ Drill Holes ☐	Power Loss/Surge ☐ Folio/Program ☐ Grain ☐ Weld ☐ Wrong Stock Pulled ☐ Out of Sequence ☐ Off-set ☐ Mislabeled ☐ Fit/Function ☐ Misaligned/off center ☐ Positioned Wrong ☐ Outside Dimensions ☐ Over/Under tolerance ☐ Part Incorrect ☐ Part Lost/Missing ☐ Part Moved ☐ Drawing ☐ Finish ☐ Misread ☐ Turning Sequence ☐			
OTHER : _____					

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Quality Control

15 OCT 05 2017 DAS 9 9-89

DAS
30
9-89

DAS
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9-89

DAS
19
9-89

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OTHER : _____					

Work Order ID 165648

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165648

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Item ID: D2052 Accept ***N900040100*** Setup Start ***NS1***
Revision ID: Stop ***NS2***
Item Name: Bracket
Start Date: 8/17/2017 Start Qty: 10.00 ***10*** Cust Item ID:
Required Date: 8/28/2017 Req'd Qty: 10.00 ***10*** Customer:
Reference:

Approvals: Process Plan: _____ Date: _____ Tooling: _____ Date: _____ Run Start ***NR1***
QC: _____ Date: _____ SPC (Y/N): _____ Date: _____ Stop ***NR2***

Sequence ID/ Work Center ID	Operation Description	Set Up/ Run Hours	Tool ID	Tool #	Plan Code	Accept Qty	Reject Qty	Reject Number	Insp. Stamp
150	Chemical Conversion Coat per QSI005 4.1	0.00							
150	HandFinish								
Hand Finishing	Memo	0.23							
						10		2017-09-12	JSL
160	Black Sandtex(Ref:4.3.5.7) per QSI005 4.3	0.00							
160	Powdercoat								
Powder Coating	Memo	0.17							
	START TIME: 11:20								
	OVEN TEMPERATURE: 320°								
	FINISH TIME: 11:50								
170	QC3- Inspect Part Finish	0.00							
170	QC								
Quality Control	Memo	0.00							
						10x		17/09/17	DAS

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						QC / QA Coordinator Approval	
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Work Order ID 165648***165648***

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Item ID: D2052 Accept ***N900040100*** Setup Start ***NS1***
Revision ID: Stop ***NS2***
Item Name: Bracket
Start Date: 8/17/2017 Start Qty: 10.00 ***10*** Cust Item ID:
Required Date: 8/28/2017 Req'd Qty: 10.00 ***10*** Customer:
Reference:

Approvals: Process Plan: _____ Date: _____ Tooling: _____ Date: _____ Run Start ***NR1***
QC: _____ Date: _____ SPC (Y/N): _____ Date: _____ Stop ***NR2***

Sequence ID/ Work Center ID	Operation Description	Set Up/ Run Hours	Tool ID	Tool #	Plan Code	Accept Qty	Reject Qty	Reject Number	Insp. Stamp
180	Identify as per dwg & Stock Location: <u>GA</u>	0.00							
180									
Packaging	Memo	0.00							
Packaging	LOCATION : GA								
190	QC21- Final Inspection - Work Order Release	0.00							
190									
QC	Memo	0.00							
Quality Control									

 SEP 20 2017

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Description Work Order Deviation		Disposition			Completed By	
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OTHER :						

Picklist Print

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Page 1

Work Order ID: 165648

165648

Parent Item: D2052

D2052

Parent Item Name: Bracket

Start Date: 8/17/2017

Required Date: 8/28/2017

Start Qty: 10.00

Required Qty: 10.00

Comments: IPP C01.08.21Added Finishing SM(Issue this IPP with part number D2053)
IPP Rev:D now water jet 07-10-25 DD
IPP Rev:E 08-05-14 chg to revD as per ECN1171 DD verified by:EC

Component Item ID/ Item Name	Replacement Item ID	Mfg/ Purch	Bin Item	Primary Location	Last Location	Route Seq ID	Unit of Measure	Qty on Hand	Qty per Kit	Total Qty	Qty Issued	Date Issued	Status
M5052H32S.090		Purchased		No		100	sf	52.8000	0.129	1.357895			
M5052H32S 090									**				DAS 40 9-89
5052-H32 .090 Sheet													

Location

Loc Qty

Loc Code

MAT

52.8

m131392

52.8

17/09/03

1.5

DQA: _____ Date: _____

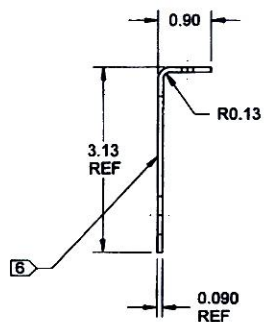


WORK ORDER NON-CONFORMANCE / UPDATE

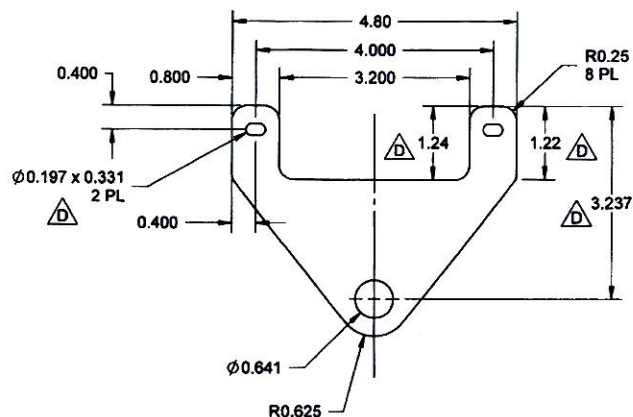
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OTHER : _____					



D2052 BRACKET



D2052F FLAT PATTERN

NOTES:

- 1) MATERIAL: 5052-H32 ALUMINUM SHEET 0.090 THICK PER QQ-A-250/8 OR AMS 4016 (REF DART SPEC M5052H32S.090) OR 6061-T6 (OR-T62) ALUMINUM SHEET 0.090 THICK PER QQ-A-250/11 OR AMS 4025/4027 (REF DART SPEC M6061T6S.090)
- 2) FINISH: CHEMICAL CONVERSION COAT PER DART QSI 005 4.1 POWDER COAT BLACK SANDEX (4.3.5.7) PER DART QSI 005 4.3
- 3) TOLERANCES: PER DART QSI 018 UNLESS OTHERWISE NOTED
- 4) UNITS: INCHES UNLESS OTHERWISE NOTED
- 5) BREAK SHARP EDGES: 0.005 TO 0.010 MAX
- 6) IDENTIFICATION: IDENTIFY WITH DART P/N "D2052" USING FINE POINT PERMANENT INK MARKER OR LABEL AFTER FINISH
- 7) WEIGHT: 0.08 lbs

SHOP COPY
RETURN TO
ENGINEERING
UNCONTROLLED COPY
SUBJECT TO AMENDMENT
WITHOUT NOTICE
WORK ORDER
NO. 165648

Aug 30 2007

RELEASED
08-05-12

D	WIDEN SLOT (ZN B7-1); UPDATE FLAT PATTERN DIMENSIONS (ZN B5-1, B6-1); ADD 6061-T6 OPTION (ZN A5-1); ADD CHEMICAL CONVERSION COAT AND CHANGE TO BLACK SANDEX (ZN A6-1); ADD IDENTIFICATION (ZN A4-1); ADD WEIGHT (ZN A3-1); ADD GRAIN DIRECTION (ZN B4-1); REASON: PRODUCT IMPROVEMENT (REF PAR 08-012)	PH	08.04.28
C	ADD FLAT PATTERN	RF	99.04.30
B	ADD SLOT TO FOOT	BW	97.02.21
A	NEW ISSUE	BW	92.01.12
REV.	DESCRIPTION	BY	DATE
DESIGN	BW	DART AEROSPACE LTD HAWKESBURY, ONTARIO, CANADA DRAWING NO. D2052 TITLE BRACKET COPYRIGHT © 1992 BY DART AEROSPACE LTD THIS DOCUMENT IS PRIVATE AND CONFIDENTIAL, AND IS SUPPLIED ON THE EXPRESSED CONDITION THAT IT IS NOT TO BE USED FOR ANY PURPOSE OR COPIED OR COMMUNICATED TO ANY OTHER PERSON WITHOUT WRITTEN PERMISSION FROM DART AEROSPACE LTD.	
DRAWN	PL		
CHECKED	CP		
ENGR. APPR.	AK		
APPROVED	AK		
DE APPR.	AK	REV. D	
DATE	08.04.28	SHEET 1 OF 1	
		SCALE	
		NTS	

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